

Date: Wednesday, 2/20/2008 4:17:58 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET LID ASSEMBLY
 Job Number : 37513B
 Estimate Number : 10207
 P.O. Number :
 This Issue : 2/20/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2989043
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2989 UNDER REVIEW pet 03.02.21
 Drawing Revision : B
 Previous Run : 37512B Material :
 Due Date : 3/15/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 080221
 Comment : Est Rev:1 Removed D2989-041 05-11-03 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D31821 Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch
 2 D3182-1 Hinge 026483

FC 08 04 01

2.0 D34423 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch
 2 D3442-3 Shim 037160

FC 08 04 01

3.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)

Pick:

Qty Part number Description Batch
 8sf M304EX0.75-16F Expanded Metal M107511

FC 08 04 01

4.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)

3/4" x 3/4" x 0.065" wall 304/316 SStubing.

Batch: M107511

FC 08 03 31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:17:58 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 37513B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note: D2989-3/-4 On -041 Bom

FC

2-Drill holes in tubing as D2989-043 per Dwg D2989

FC

3-Deburr and remove all markings on material

FC

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

FC 08 04 01

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-04-08 ①

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 08-04-08 ①

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M 107550

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

① - BL 08-04-08

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

ml 08/04/09

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/09

Job Completion



NMF 08-04-09

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN DS | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2989 | REV. B SHEET 1 OF 3 |
| DATE 05.06.07 | | TITLE BASKET LID ASSEMBLY | SCALE NTS |
| A | 00.10.27 | NEW ISSUE | |
| B | 05.06.07 | ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS | |

RELEASED

05-08-19 *[Signature]*

PARTS LIST:

| Qty -041 | Qty -043 | Part Number | Description |
|-------------|-------------|-------------|-------------------------------|
| X | | D2989-041 | BASKET LID ASSEMBLY (OUTSIDE) |
| | X | D2989-043 | BASKET LID ASSEMBLY (INSIDE) |
| | 1 | D2989-1 | STRUT |
| | 1 | D2989-2 | STRUT |
| | 1 | D2989-3 | STRUT |
| | 1 | D2989-4 | STRUT |
| | 2 | D2989-5 | STRUT |
| | 2 | D2989-7 | STRUT |
| 1 | | D2989-9 | STRUT |
| 1 | | D2989-10 | STRUT |
| 1 | | D2989-11 | STRUT |
| 1 | | D2989-12 | STRUT |
| 2 | | D2989-13 | STRUT |
| 2 | | D2989-15 | STRUT |
| 2 | | D2327-3 | SPACER BUSHING |
| 1 | | D2506 | LABEL PLATE |
| 2 | 2 | D2989-17 | STRUT (96.00" LONG) |
| 2 | | D2989-19 | STRUT (31.19" LONG) |
| 1 | | D2512-7 | STRUT |
| 2 | | D2581 | MOUNTING BRACKET |
| | 2 | D3182-1 | HINGE |
| | 2 | D3442-3 | SHIM |

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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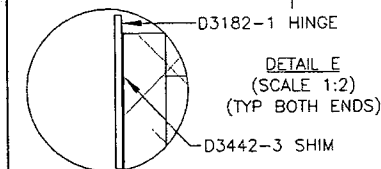
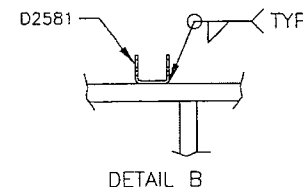
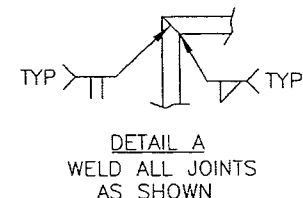
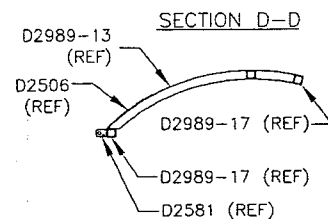
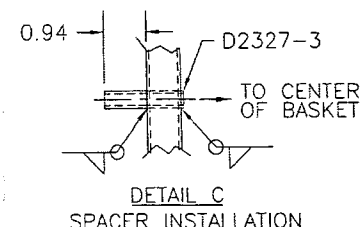
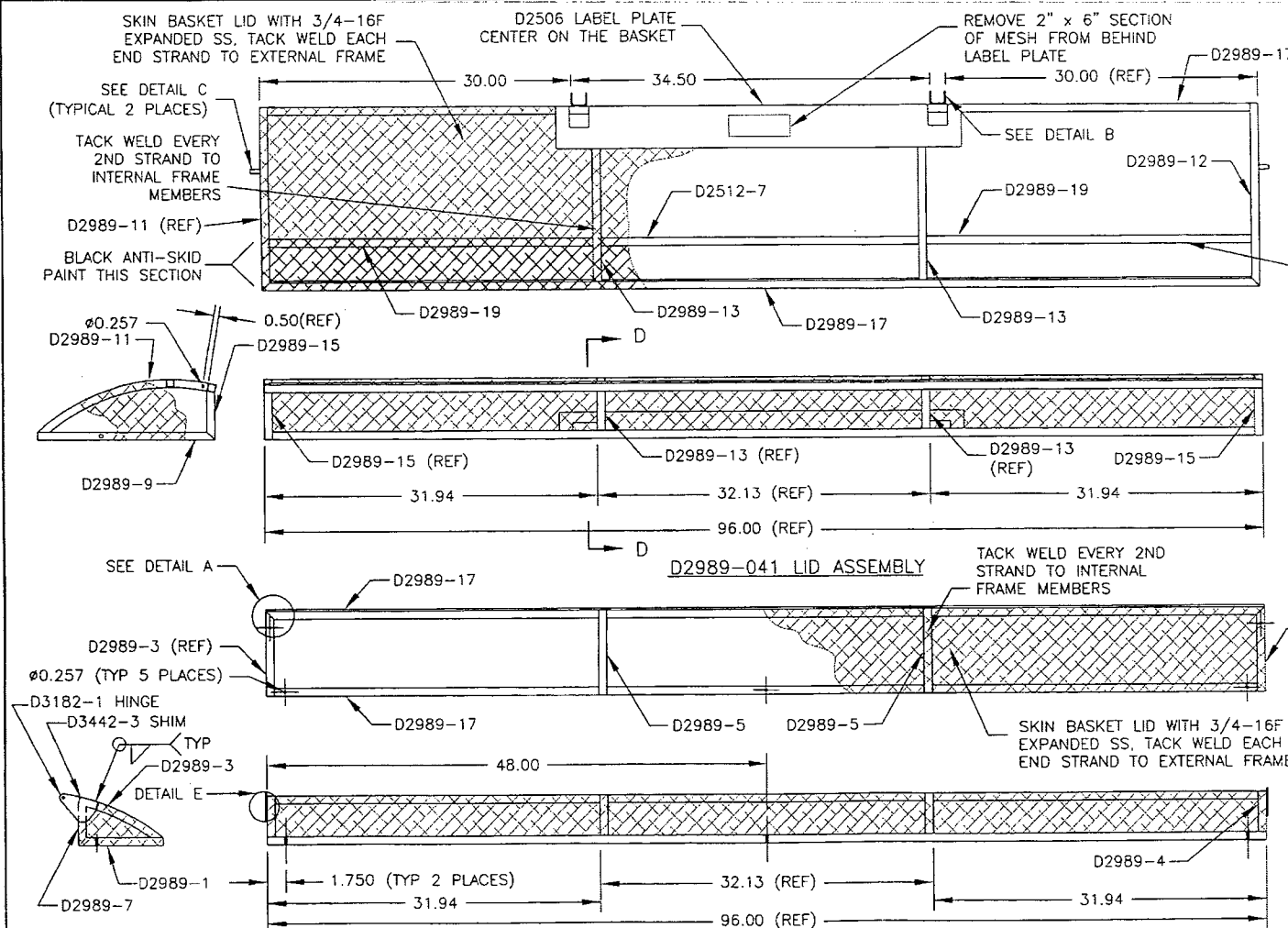
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UNDER REVIEW

03-08-05 PH
TUBING TO BE
CHANGED TO 0.065
WALL
03-02-21

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WITHOUT NOTICE
WORK ORDER
NO. 37513B

0.065 PH 03-02-21



UNDER REVIEW
08.06.05 PH
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CHANGED TO 0.065
WALL
08.02.21

D2989-043 LID ASSEMBLY

NO. 17513B

WORK ORDER

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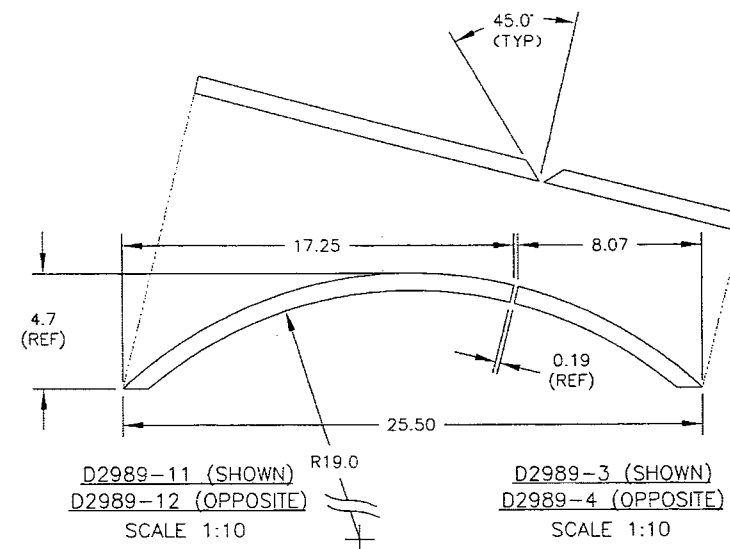
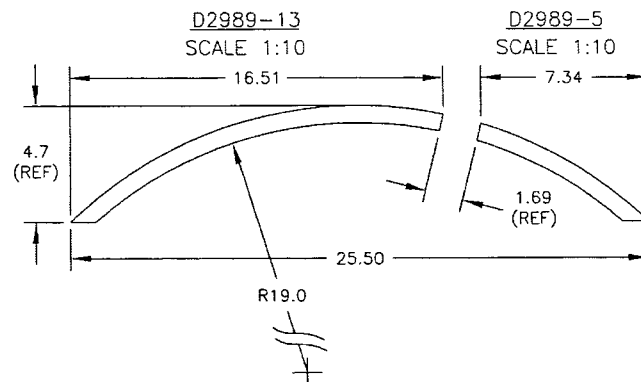
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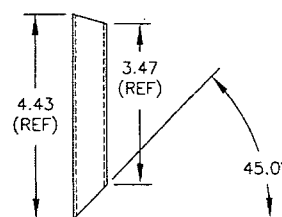
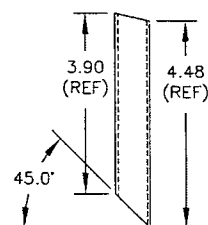
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| CHECKED # | | APPROVED # | | DRAWING NO. D2989 | REV. B |
| DATE 05.06.07 | | | | TITLE BASKET LID ASSEMBLY | SHEET 2 OF 3 |
| | | | | | SCALE 1:10 |

RELEASED
05.06.07

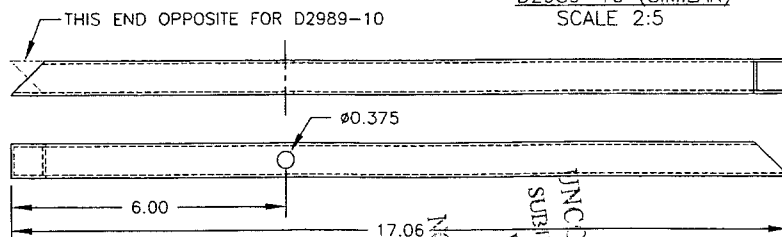


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SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

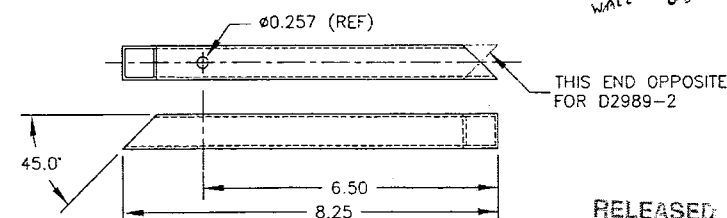
D2989-7
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



D2989-9 (SHOWN)
D2989-10 (SIMILAR)
SCALE 2:5



D2989-1 (SHOWN)
D2989-2 (OPPOSITE)
SCALE 2:5



UNDER REVIEW
08-03-05 PH
TUESDAY TO BE
CHANGED TO DUES PH
WALL 08-03-21

RELEASED
05-03-19

| | | | | | |
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